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Hawkesbury, ON
K6A 1K7
Canada
Tel (613) 632-5200
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D2432
Job Sheet 188299



Job Qty: 24 pcs

Part No: D2432

Part Name: Bearpaw 19" X 24"



Part Weight: 0 lbs

Job Created: 1/7/19

Due Date: 1/18/19

Type: SOLD

Note: DWG REV H IPP REV:A 12.10.17 AS PER DWG REV.H DD VERF:JLM

Ship Via:

Priority: Medium

Status: New

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Job Routing

Standard

Workcenter/Supplier

Sign-off

Waterjet - Omax

HAAS - 1 - B4B

HAAS - 2 - B4B

HAAS - 3 - B4B

HAAS - 4 - B4B

QC 2 - 1

QC 2 - 12

QC 2 - 14

QC 2 - 17

QC 2 - 19

QC 2 - 2

QC 2 - 20

QC 2 - 22

QC 2 - 23

QC 2 - 25

QC 2 - 32

QC 2 - 33

QC 2 - 35

QC 2 - 38

QC 2 - 39

QC 2 - 4

QC 2 - 40

QC 2 - 44

QC 2 - 45

QC 2 - 48

QC 2 - 49

QC 2 - 50

QC 2 - 51

QC 2 - 52

QC 2 - 54

QC 2 - 56

QC 2 - 57

140 QC 2 24 pcs 1/18/19 0.00 0.00

130 HAAS 4 Axis - B4B 24 pcs 1/18/19 0.36 30.04

120 Waterjet - Omax - 1 24 pcs 1/18/19 0.00 6.19

No Operation Qty Start Date Date

Op Due Setup Run Hrs Hrs

Workcenter/Supplier

Bill of Materials

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

150 QC 8	24 pcs	1/18/19	0.00	0.00	QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 8 - 12	mk 1/12/02
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 38	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
160 Packaging 3-1 - Stock - B4B 24 pcs		1/18/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	ST 445 FEB 04 2019
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

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Other/Details:					

170 QC 21 - SA 24 pcs 1/18/19 0.00 0.00

DAG
21
9-88

FEB 04 2019

Part Op 120 - Waterjet 2 OMAX (Waterjet 2) Cut Blank as per D2432 File

Descriptions: 130 - (HAAS CNC vertical machine #1) 1-Inspect material for defects or damage prior to machining 2-Machine as per

Folio and Dwg D2432 Identify as D2432F 3-Debur

140 - (QC2- Inspect parts off machine FAI/FAIB)

150 - (QC8- Inspect parts - second check)

160 - (Identify as per dwg & Stock Location:_____)

170 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	88.8000 sf (3.7 ea)	120-Waterjet - Omax - 1	S/43330

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
120-Waterjet - Omax - 1	MUHMWB10	89	62	0

Part Specifications

Specifications could not be found.

Plex 1/7/19 2:07 PM Dart.lajeunesse.marie

Entered: _____ Date: _____



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DART AEROSPACE LTD		Work Order:	185299
Description: Bearpaw		Part Number:	D2432
Inspection Dwg: D2432 Rev: H		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.063 x 45°	✓		Ver	
B	0.200	+/-0.030	0.200	✓		D.G.	
C	0.25 x 45°	+/-0.030	0.25 x 45°	✓		Ver	
D	R0.250	+/-0.030	R0.25	✓		R.G.	
E	0.250	+/-0.010	0.250	✓		Ver	
F	0.625	+/-0.030	0.630	✓		Ver	
G	0.375	+0.030/-0.010	0.385	✓		Ver	
H	0.950	+/-0.030	0.960	✓		Ver	
I	19.000	+/-0.030	19.000	✓		TAPE	
J	Ø0.260	+0.005/-0.000	Ø0.260	✓		G.P.	
K	Ø0.93	+/-0.030	0.930	✓		Ver	
L	0.30	+0.030/-0.000	0.315	✓		D.G.	
M	23.750	+/-0.030	23.750	✓		TAPE	
N	2.000	+/-0.030	2.000	✓		Ver	
O	0.38	+/-0.030	0.38	✓		Ver	
P							
Q							
R							
S							
T							
U							
V							

Measured by: 52 9-89	Audited by: [Signature]	Preliminary Approval:
Date: 19/01/29	Date: 19/02/02	Date:

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O D206-559-015	KJ/RF	
B	12.07.31	Dwg Rev updated	KJ	
C	12.10.26	Dwg Rev updated	KJ	
D	13.07.18	Dimension 7.375 removed	KJ	
E	15.02.09	Dimensions revised	KJ	[Signature]



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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Container No: S145881



Part: D2432

Job No: 188299

Serial No/Batch: S145881

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 01/17/19